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D4435-9
Job Sheet 185834



Part No: D4435-9

Job Qty: 20 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/18

Job Tracking No:

Due Date: 11/19/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 10,11 IPP REV:A NEW ISSUE 11-12-22 JLM VERIFIED BY:EC IPP REV:B 12.01.24
PER DWG REV.A DD VERF:EC IPP REV:C 12.03.06 AS PER DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/19/18	0.00	1.11	Waterjet - Flow		SC 18/11/06
120	QC	20 pcs		11/19/18	0.00	0.00	QC8		38
130	Brake NC	20 pcs		11/19/18	0.03	0.59	Brake NC 2		DAS 9-89 5B
140	QC	20 pcs		11/19/18	0.00	0.00	QC5		38
150	HandFinish	20 pcs		11/19/18	0.00	0.53	HandFinish1		DR 18/11/08
160	QC	20 pcs		11/19/18	0.00	0.00	QC7-3		DR 18-11-8
165	Powdercoat	20 pcs		11/19/18	0.00	0.32	Powdercoat4		DR 18-11-8
170	QC	20 pcs		11/19/18	0.00	0.00	QC3		DAS 9-89 38
180	Packaging	20 pcs		11/19/18	0.00	0.00	Packaging3-2	54091 6	NOV 13 2018
190	QC21-SA	20 Ea		11/19/18	0.00	0.00	QC21	9-89	DAS 9-89 NOV 13 2018

11 135889

START: 2:10

OUT: 3:20 FINISH: 2:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.4400 sf (.022 ea)	100-Waterjet - Flow - 1	5099479

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	0	231	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	1.250Inches $\pm$ 0.030	1.280 1.220	1.251	
2	Bracket	2.800Inches $\pm$ 0.030	2.830 2.770	2.803	
3	Bracket	0.098Inches + 0.005 - 0.001	0.103 0.097	0.098	Diameter
4	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100	0.131	
5	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100	0.129	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____ QTV Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

Container No: S124805

Part: D4435-9

Job No: 185834

Serial No/Batch: S124805

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Date: 11/06/18

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CANADA

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Root Cause

Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Wrong Stock Pulled	☐	Part Lost/missing	☐
Design	☐	Operator	☐	Bending	☐	Out of Sequence	☐	Part Moved	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentr	☐	Off-set	☐	Drawing	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Mislabeled	☐	Finish	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Fit/Function	☐	Misread	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Misaligned/off center	☐	Turning Sequence	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐				
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐				
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐				
Substation	☐	Process Improvement	☐	Marks/Chatter	☐				
Past Expiry Date	☐	Manufacturing Process	☐						
Misidentified	☐	Past Due	☐	OTHER : _____					

6

Bracket

0.040Inches $\pm$ 0.010

0.050

0.030

0.038

Plex 11/5/18 9:01 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								